
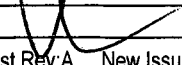


Date: Thursday, 06/07/2006 3:24:56 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 27841	
Estimate Number : 10384	
P.O. Number : N/A	Part Number : D3195043
This Issue : 06/07/2006 S.O. No. : N/A	Drawing Number : D3195 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 06/07/2006 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 26303	Material : N/A
Written By : 	Due Date : 13/07/2006 Qty: 25 Um: Each
Checked & Approved By : 	
Comment : Est Rev: A New Issue 05-11-08 JLM	

Additional Product

Job Number:



Seq. #:	Machine Qr Operation:	Description :
----------------	------------------------------	----------------------

1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"
-----	--------------------	--------------------------



Comment: Qty.: 0.3150 f(s)/Unit Total: 7.8750 f(s)
Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) or (QQ-A-250/11)
(M6061T6B1.250x1.500)
Identify for D3195-3
Batch: M101694

JML 06/08/02

25

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blanks: (1.250" x 1.500") x 3.60" long

JML 06/08/02

25

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-3

2-Deburr

JML 06/08/02

25

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JML 06/08/02

25

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.F. 06/08/04

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 06/07/2006 3:24:56 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 27841

Part Number: D3195043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m

06-08-09

(25)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

a.m

06-08-10

(25)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-08-21

9.0

D31957

Pad



Comment: Qty.: 1.0000 Each(s)/Unit Total: 25.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3195-7

PAD

27325

✓

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Lightly Sand bonding surface & wash clean with wash'n wipe & cross solvent

2-Bond D3195-7 into D3195-13as per Dwg D3195

A/R Contact Cement

M16194

mlo 06/08/16

(PTO)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-08-21

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

52413

(25)
AR 06/08/22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-08-16	10.	Add clean with wsh'n wipe AS shown. Perm. Change				VS 06/08/16	06-08-16	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-08-16	10	Parts not sanded before bonding.	VS 06/08/16	re-do i sand i clean. Have to scrap all D3195-7 paa. Take new one in stock. Same batches	ml 06/08/16	06-08-21	VS 06/08/16	06-08-16

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/08/23

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 06/07/2006 3:24:57 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 27841

Part Number: D3195043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

06.08.23

Job Completion



C206108122

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	
Description: Bracket		Part Number:	D3195-3
Inspection Dwg: D3195 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.432	+/-0.010	3.432	✓			
1.265	+/-0.010	1.259	✓			
R0.37	+/-0.030	R0.37	✓			
Ø0.277	+0.005/-0.000	Ø0.278	✓			
2.677	+/-0.005	2.677	✓			
0.242	+/-0.010	0.245	✓			
0.377	+/-0.010	0.379	✓			
0.500	+/-0.010	0.501	✓			
R0.188	+/-0.010	R0.188	✓			
0.250	+/-0.010	0.251	✓			
0.882	+/-0.010	0.880	✓			
1.250	+/-0.010	1.251	✓			
0.500	+/-0.010	0.500	✓			
Ø0.191	+0.005/-0.000	Ø0.191	✓			
1.000	+/-0.010	1.001	✓			

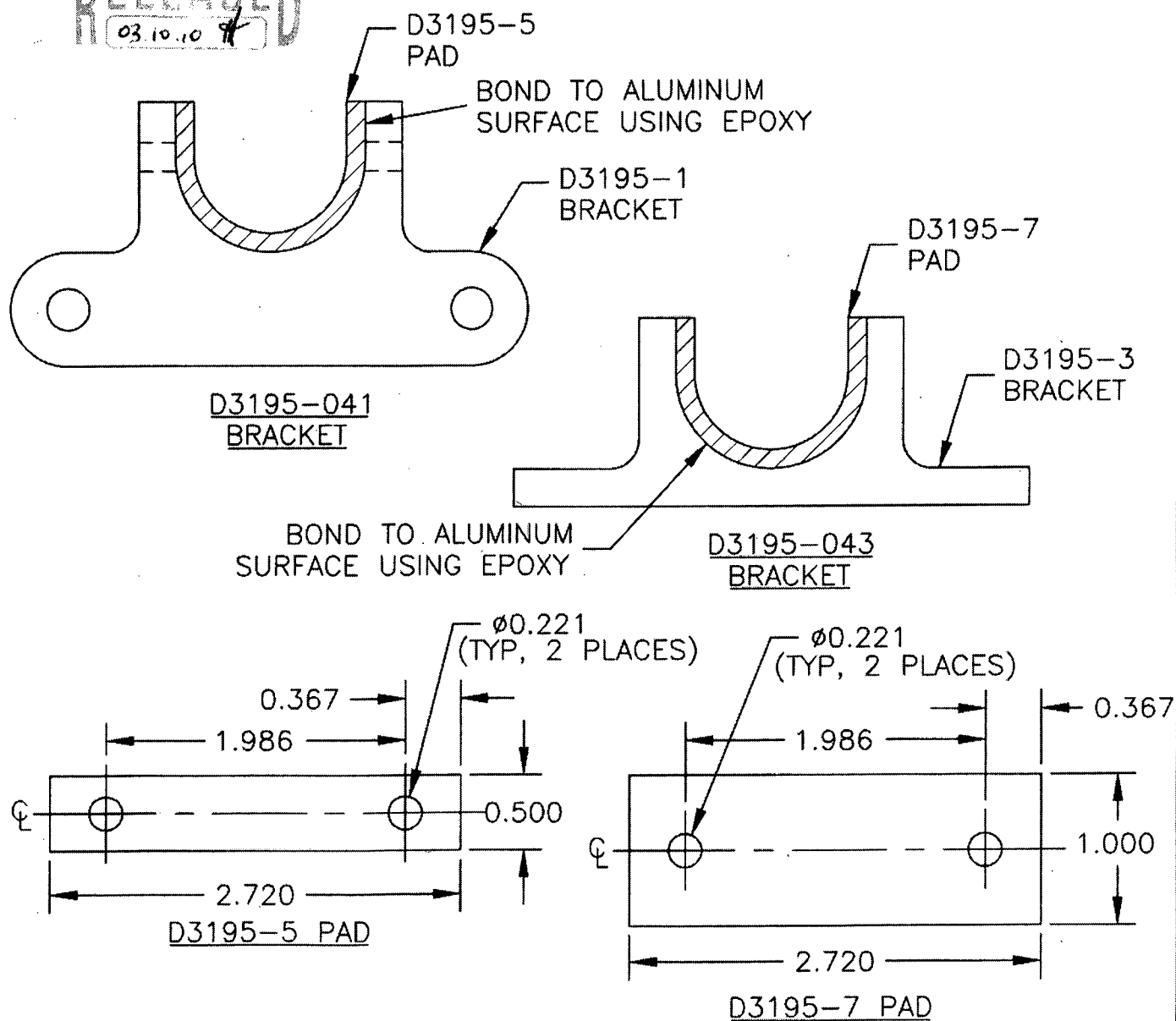
Measured by:	<i>JK</i>	Audited by:	<i>J.L</i>	Prototype Approval:	N/A
Date:	06/08/02	Date:	06/08/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-013)	KJ/RF	
B	05.04.26	R0.37 was R0.037; 1.084 removed	KJ/JLM	



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3195	REV. A SHEET 1 OF 3
DATE 03.06.23	TITLE BRACKET		SCALE 1:1
A	03.06.23	NEW ISSUE	

RELEASED
03.10.10



D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

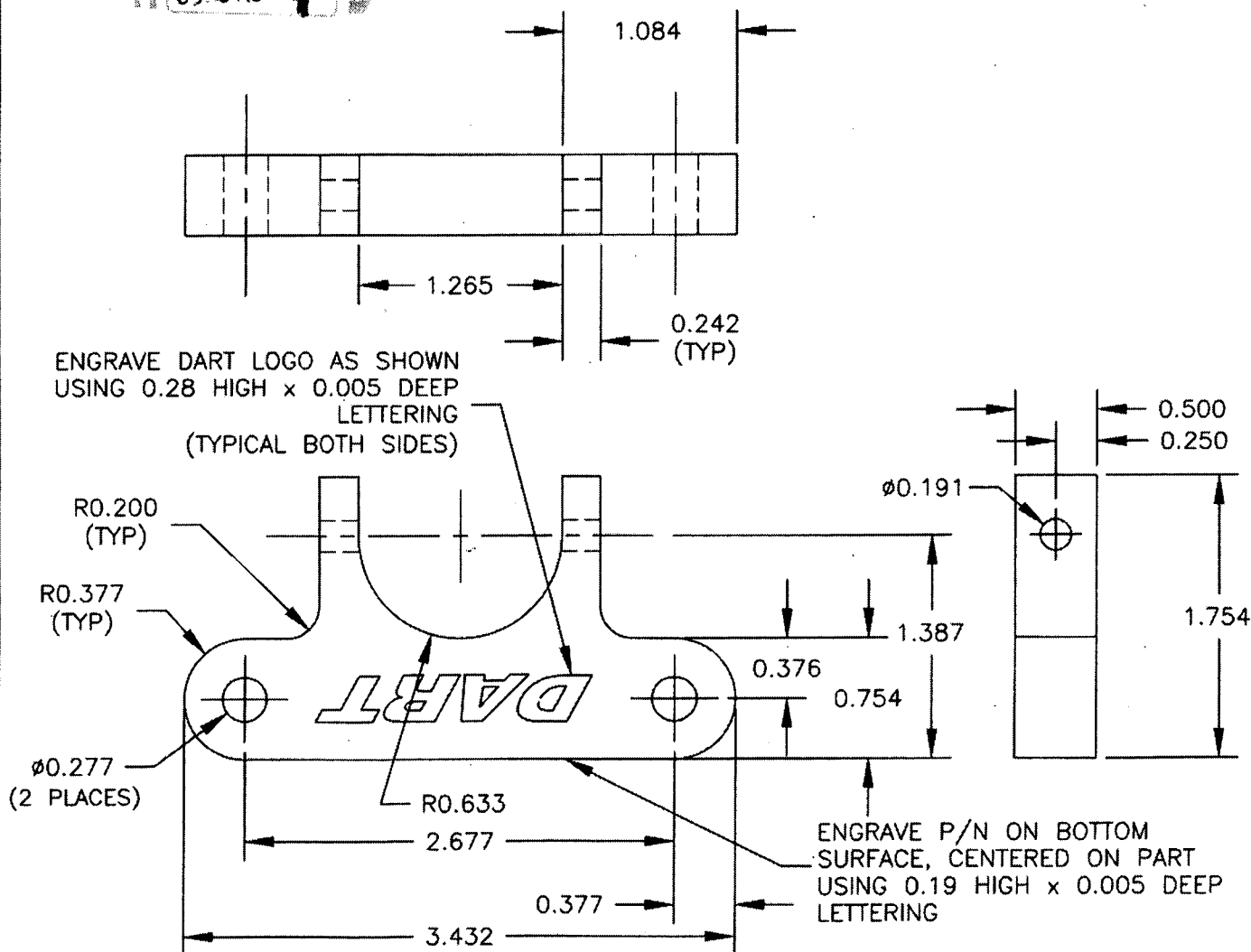
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3195	REV. A SHEET 2 OF 3
DATE 03.06.23	TITLE BRACKET		SCALE 1:1

RELEASED
03.10.10



D3195-1 BRACKET

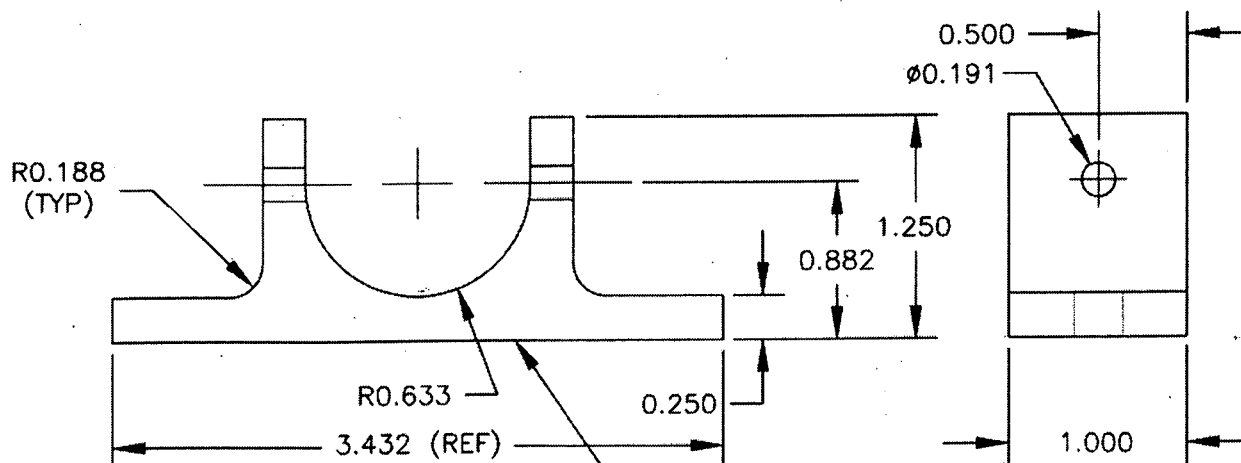
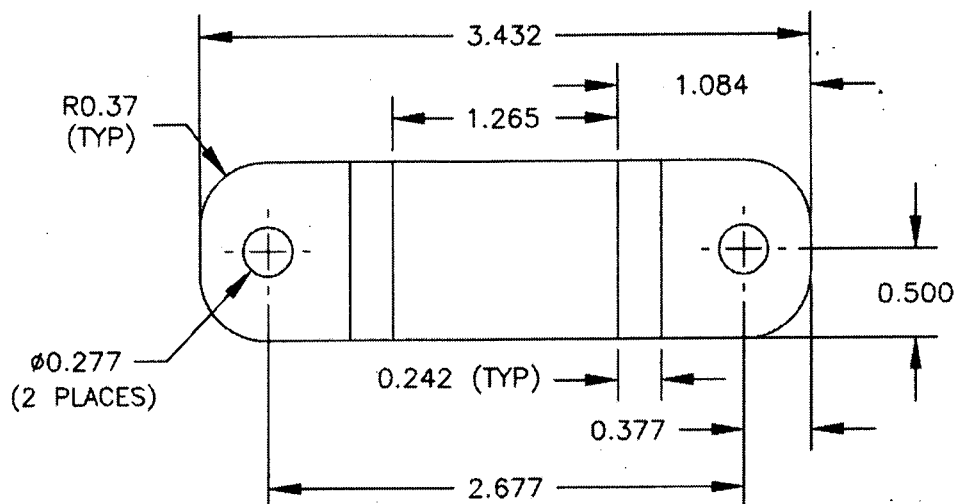
- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI-018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D3195	REV. A SHEET 3 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1



RELEASED
03.10.10

ENGRAVE P/N ON BOTTOM
SURFACE, CENTERED ON PART
USING 0.19 HIGH x 0.005 DEEP
LETTERING

D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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